

METHOD AND APPARATUS FOR APPLYING A  
POLYCHROMATIC COATING ONTO A SUBSTRATE

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Abstract of the Disclosure

A method is provided for coating a substrate. A first waterborne coating material which is substantially free of effect pigment is applied over the substrate by one or more bell applicators. A second waterborne coating material comprising effect pigment is applied over the first coating material by one or more bell applicators. Between application of the first and second basecoat materials, the first basecoat material can be stabilized by exposing the first basecoat material to air having a temperature ranging from about 50°F(10.0°C) to about 90°F (32.5°C), a relative humidity of about 40% to about 80% and an air velocity at the surface of the coating material of about 20 FPM (0.10 m/s) to about 150 FPM (0.76 m/s) for a period of about 10 to about 180 seconds.

20 A coating application system is also provided. The system includes a first supply of at least one first coating component which is substantially free of effect pigment and a second supply of at least one effect-pigmented coating component. At least one mixer is provided for dynamically mixing the effect pigment-free coating component and/or the effect pigmented coating component to form a mixed coating material. The mixed coating material is received from the mixer and applied over the substrate by a bell applicator.